

Work Order ID 67470

Tuesday, March 22, 2011 1:43:13 PM

Ship 31st



Ship #877

Page 1

Item ID: D4078-1

Accept



Setup Start



Revision ID:

Item Name: Clamp Half

Stop



Start Date: 3/22/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 3/30/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals:

Process Plan: CMF

Date: 11-03-20

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4078

B

100

0.00



Bandsaw

Memo

0.00

Jcaspa Bandsaw

Cut blank 2.700" long

JK 11/03/22

(16)

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Mill as per Dwg and Folio FA929

Folio rev: AA

Dwg Rev: B

CMF 11/03/29

16

Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67470

Tuesday, March 22, 2011 1:43:14 PM

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Item ID: D4078-1

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Setup Start

Revision ID:

Stop

Item Name: Clamp Half

Start Date: 3/22/2011 Start Qty: 16.00

Cust Item ID:

Required Date: 3/30/2011 Req'd Qty: 16.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

mk 11/03/29

16 ~~10~~

QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

B.A 11/03/29

16 ~~0~~

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

16 BR 11-3-30



HandFinish

Memo

0.00

Hand Finishing

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 3/30/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

M115128

Memo

START: 11:15
WENT: 3:20
FINISH: 11:45

16 BR 11-3-30

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

16 φ M 4/03/30

170



Packaging

Packaging

Identify as per dwg & Stock Location: ST121

0.00

Memo

0.00

16 4/11/3/30 (16)

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Revision ID:

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Item Name: Clamp Half

Start Date: 3/22/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 3/30/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

4/3/30 [Signature]
ME
11-03-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Tuesday, March 22, 2011 1:43:10 PM

Page 1

Work Order ID: 67470



Parent Item: D4078-1



Parent Item Name: Clamp Half

Start Date: 3/22/2011

Required Date: 3/30/2011

Start Qty: 16.00

Required Qty: 16.00

Comments: Ipp Rev:A New Issue 10-05-07 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X01.25 0		Purchased	No			100	f	18.9341	0.223	3.755789			



6061-T6 Bar 1.25 x 1.25



JL 11/03/22

Location

Loc Qty

Loc Code

MAT003

18.93400526

106259

7.06910526

110001

0.22524

116135

11.63966

MAT03

0.000105263

106259

0.00010526

3.8

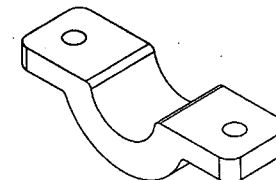
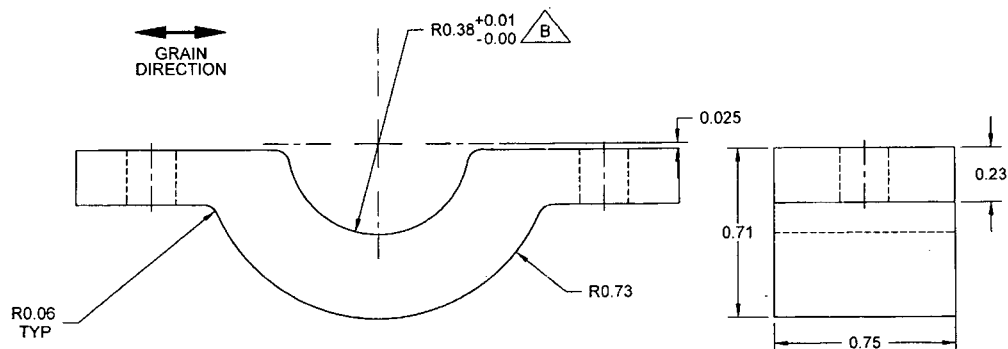
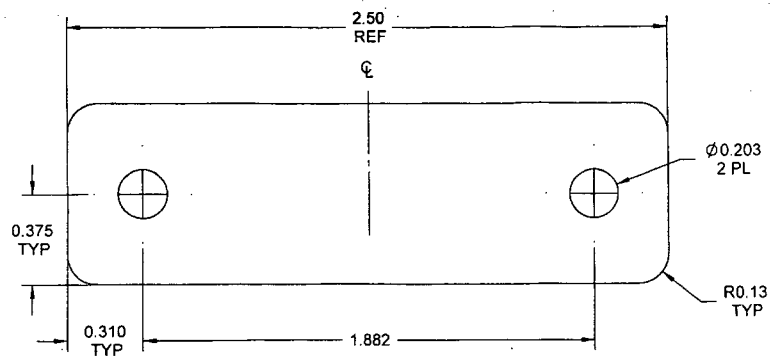
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#67470

RELEASED
2010-09-07
WP

D4078-1 CLAMP HALF

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4078-1" USING WHITE FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs

B	R0.38 was R0.48.	18	10.07.30
A	NEW ISSUE	18	10.02.08
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.07.30		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4078** REV. B
TITLE **CLAMP HALF** SCALE NTS

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